

Work Order ID 80942

Monday, March 05, 2012 4:55:21 PM

80942

Ship March 19th Page 1

Item ID: D4032-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MUF*Date: *12-03-06* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4032	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

*6/12/3/15 (1)**2/5/12/03/19 (2)**12 03 19 (1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 80942***80942***

Page 2

Item ID: D4032-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

P1180941

0.00

Packaging

12/3/19

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/03/19
MF
12-03-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Picklist Print

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Page 1

Work Order ID: 80942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10
verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP
Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232 Placard, Max Load		Manufactured	No			100	Each	11.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		11							
				72052		1							
				78969		10			78969				
D2530 Handle Weldment		Manufactured	No			100	Each	13.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		13							
				77030		7			77030				
				78965		6							
D2535 Spring		Manufactured	No			100	Each	52.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		52							
				71117		2							
				77488		50			77488				
D2537 Bushing		Manufactured	No			100	Each	42.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		42							
				76088		2							
				77055		40			77055				

12/3/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 80942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

D3917-3
Washer

Manufactured No

100 Each 31.0000 6 6

Location

Loc Qty

Loc Code

ST070

31

76956

5

80598

26

D3953-3
Gas Spring Stud, Lid

Manufactured No

100 Each 30.0000 2 2

Location

Loc Qty

Loc Code

ST075

30

76659

10

78042

20

D3953-7
Spring Spacer

Manufactured No

100 Each 18.0000 2 2

Location

Loc Qty

Loc Code

ST075

18

76295

18

D3953-9
Gas Spring Washer

Manufactured No

100 Each 22.0000 2 2

Location

Loc Qty

Loc Code

ST075

22

76296

2

78916

20

D3953-17
Gas Spring Spacer

Manufactured No

100 Each 11.0000 2 2

Location

Loc Qty

Loc Code

ST075

11

76294

11

D3953-19
Gas Spring Bracket

Manufactured No

100 Each 16.0000 1 1

Location

Loc Qty

Loc Code

ST075

16

75227

16

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Page 2

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Work Order ID: 80942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-21
Gas Spring Bracket

Manufactured No

100 Each 3.0000

1

1

Location

Loc Qty

Loc Code

ST075

3

73557

3

73557

D3969-3
Spring (Basket Lid)

Manufactured No

100 Each 17.0000

1

1

Location

Loc Qty

Loc Code

ST272

17

64285

1

73515

16

73515

D4017-041
Short Basket Base Assembly (350)

Manufactured No

100 Each 0.0000

1

1

D4018-041
Short Basket Lid Assembly (350)

Manufactured No

100 Each 0.0000

1

1

AN3-14A
Bolt

Purchased No

100 Each 102.0000

4

4

Location

Loc Qty

Loc Code

ST352

102

117872

2

119328

100

119328

AN3-16A
Bolt

Purchased No

100 Each 95.0000

2

2

Location

Loc Qty

Loc Code

ST352

95

117441

49

118628

46

118628

AN4-12
Bolt

Purchased No

100 Each 45.0000

3

3

Location

Loc Qty

Loc Code

ST357

45

118626

20

119775

25

118626

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Work Order ID: 80942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No

100 Each 100.0000 4 4

Bolt

Location	Loc Qty	Loc Code
FP001	8	
119438	8	
ST338	92	
117872	42	
120498	50	

AN310-4 Purchased No

100 Each 56.0000 3 3

NUT

Location	Loc Qty	Loc Code
ST344	56	
120124	31	
120518	25	

AN310C4 Purchased No

100 Each 55.0000 2 2

Nut

Location	Loc Qty	Loc Code
ST344	55	
119324	25	
120360	30	

MS21042L3 Purchased No

100 Each 3,681.0000 6 6

Nut

Location	Loc Qty	Loc Code
ST300	3681	
117441	16	
117885	32	
118451	5	
118927	3	
119017	3428	
119075	197	

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Work Order ID: 80942

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No

100 Each 1,700.0000 4 4

Nut

Location	Loc Qty	Loc Code
ST300	1700	
116105	5	
116548	43	
117611	42	
118179	110	
119109	1500	

MS24665-151 Purchased No

100 Each 323.0000 3 3

Cotter Pin

Location	Loc Qty	Loc Code
ST309	323	
17566	323	

MS24665-300 Purchased No

100 Each 214.0000 2 2

Cotter Pin

Location	Loc Qty	Loc Code
GA	200	
118234	200	
ST309	14	
116823	14	

NAS1149F0432P Purchased No

100 Each 238.0000 6 6

Washer

Location	Loc Qty	Loc Code
ST275	238	
120142	38	
120360	200	

NAS1149C0432R Purchased No

100 Each 2,942.0000 2 2

Washer

Location	Loc Qty	Loc Code
ST297	2942	
117291	1942	
119124	1000	

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Dart Aerospace Ltd

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Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

616.0000

8

8

WASHER

Location

Loc Qty

Loc Code

ST275

616

117735

37

119225

176

120498

200

120910

200

17317

3

119225

NAS1149F0563P

Purchased

No

100

Each

101.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST275

101

117735

101

117735

11/2/3/10 ①

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

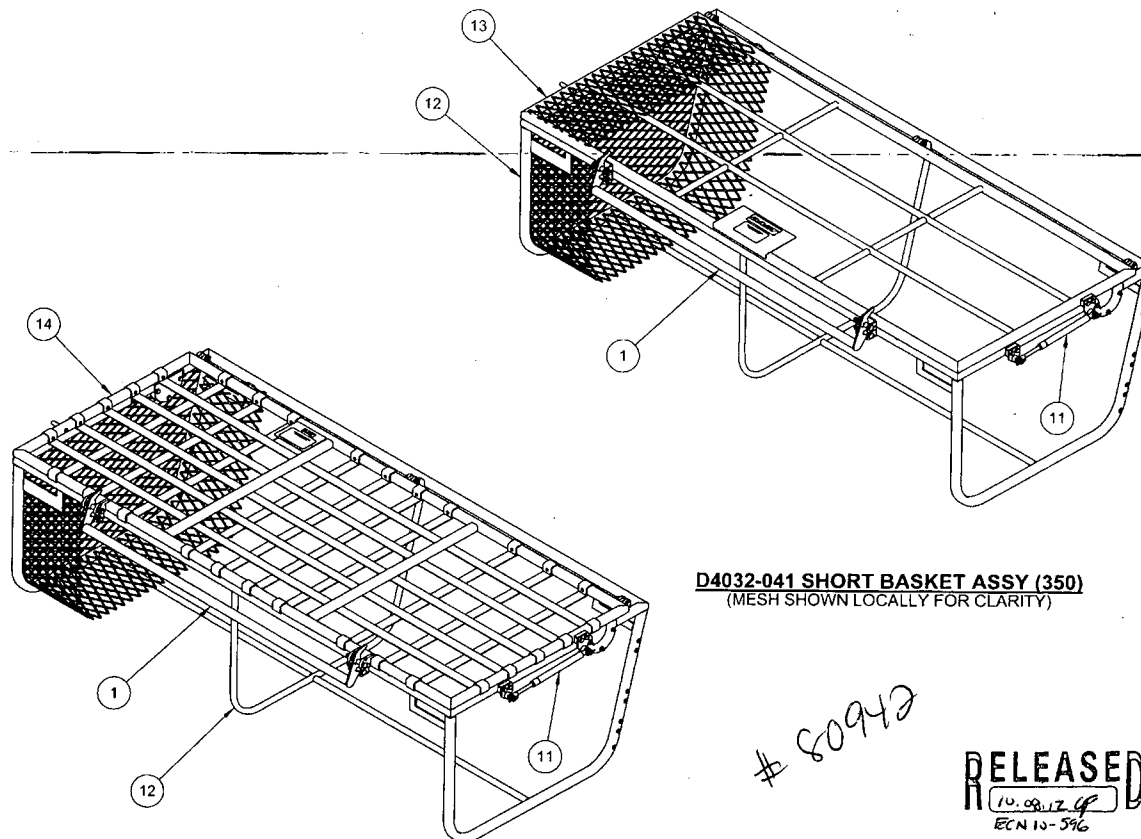
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-18A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN			
CHECKED			
MFG. APPR.	JFS		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4032	REV. D SHEET 1 OF 3
TITLE SHORT BASKET ASSY (350)	SCALE NTS
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RELEASED
10.08.17
ECN 10-596

W/O:		WORK ORDER CHANGES					
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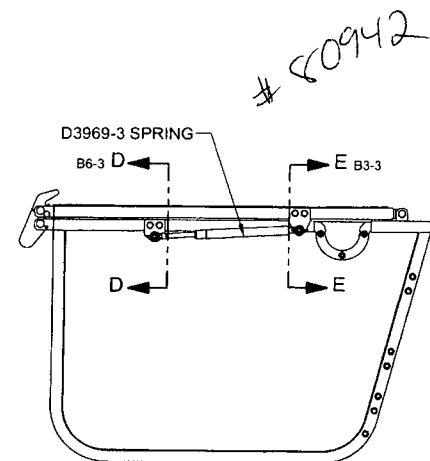
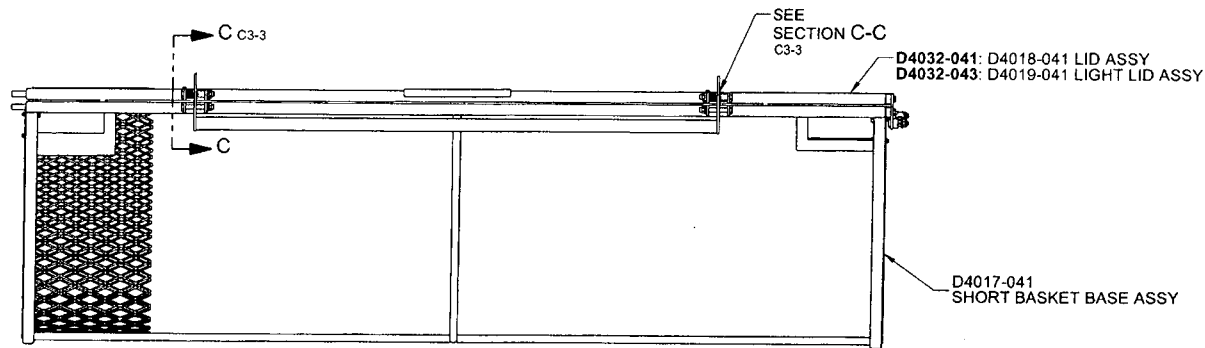
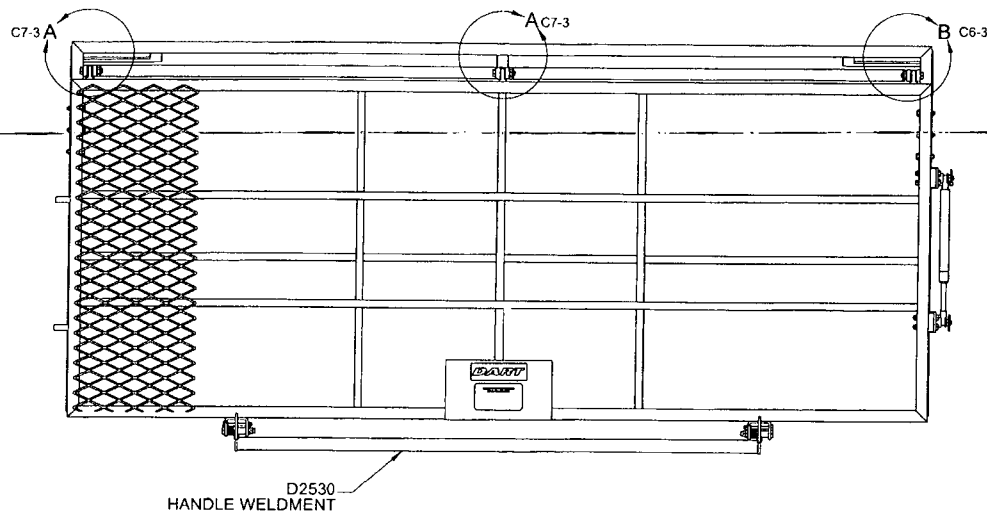
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8 7 6 5 4 3 2 1



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	D4032	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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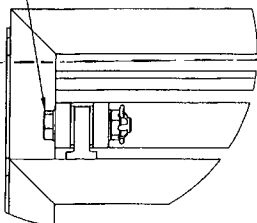
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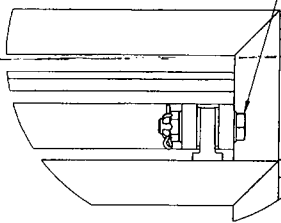
8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



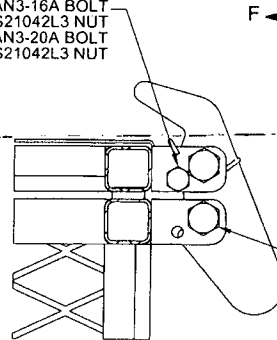
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

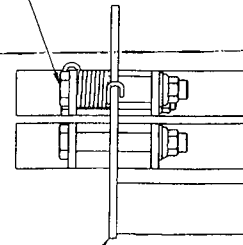


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530 WELDMENT
REF

D3953-17 GAS SPRING SPACER

D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.17.09

DESIGN	ALLS	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	J.F.S. J.L.M.	D4032	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries